



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001

Job Sheet 190699



Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		MAR 07 2019 Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	3/29/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S165035



Part: 646.4001

Job No: 190699

Serial No/Batch: S165035

Revision:

Inspector:

Exp Date: 08/18/2019

Instructions: FAA STC SR02180LA 14/08/07 TC STC SH09 -

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	QC 4	1 pcs	3/29/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	
					QC 4 - 9	DAS 46 MAR 25 2019 9-89
					QC 4 - 46	DAS 46 MAR 25 2019 9-89
130	Packaging 3-1 - Stock - B4B	1 pcs	3/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS 21 MAR 25 2019 9-88
135	DC - 1 - B4B	1 pcs	3/29/19	0.00 0.00	DC - 1 - B4B	DAS 21 MAR 25 2019 9-88
					DC - 2 - B4B	
140	QC 21 - FG	1 pcs	3/29/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	DAS 21 MAR 25 2019 9-88
					QC 21 - FG - 53	
Part Op 110 - pick kit						
Descriptions: 120 - QC4- 100% Inspect kits for completeness						
130 - Identify and pack for shipping as per PPP 646.4001 Location: _____						
135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001						
140 - QC21- Final Inspection - Work Order Release						

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5019004
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5139403
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5139402
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5152376
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5196334
646.2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5154493
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5159128
646.3110	Channel	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5154342
646.3210	Support	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5131207
646.3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5159082
646.3510	Strut	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5122440
646.3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5127662
646.3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5131480
646.3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5059684
646.3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5128060
646.3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5128050
646.3713	Gusset	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5124418
646.3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5145099
646.3715	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5139095
646.3716	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5063380
646.3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5082377
646.3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5145123
646.3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5143244
646.3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5150081
646.3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5070643
646.3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5150415
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5131319
646.3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5128166
646.3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5133609
646.3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5124372
646.3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5041498
646.9410	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056998
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5133211
647.7703	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5143539
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5131245
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5157480
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5133167
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5098032
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5131193
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5149128
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149158
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5130135
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5156448
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5071343
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5142147
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	5133189
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5140521
MS20426AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5153848
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5143406
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5048897
MS20470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5123425
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5134219
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5130347
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149814
MS21047-3	Nut Plate	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5152873
MS24693-C278	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5065341
MS24694-S51	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5123459
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5152667

Exp 9/19

5131212

MS24694-S55	Screw	3 Ea (3 ea)	110-Packaging 1 - Pick Kit
MS27039-08-13	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit
MS27039-1-10	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit
MS27039-1-12	Screw	6 Ea (6 ea)	110-Packaging 1 - Pick Kit
MS27039-1-16	Screw	24 Ea (24 ea)	110-Packaging 1 - Pick Kit
MS27039-1-19	Screw	22 Ea (22 ea)	110-Packaging 1 - Pick Kit
MS27039-1-20	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit
MS27039-1-21	Screw	4 Ea (4 ea)	110-Packaging 1 - Pick Kit
NAS1149F0332P	Washer	144 Ea (144 ea)	110-Packaging 1 - Pick Kit
NAS1149F0363P	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit
NAS1149F0432P	Washer	4 Ea (4 ea)	110-Packaging 1 - Pick Kit
NAS1149FN832P	Washer	4 Ea (4 ea)	110-Packaging 1 - Pick Kit

5099526
5123937
5148665
5124664
5140520
5155664
5094554
5104011
5157648
5075330
5152652
5183716

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	280	0
	600.0990	1	26	0
	600.0991	1	26	0
	600.1012	1	33	0
	600.1013	5	81	0
	646.2910	1	10	0
	646.3001	1	5	0
	646.3110	1	25	0
	646.3210	1	18	0
	646.3301	1	10	0
	646.3510	1	21	0
	646.3511	1	21	0
	646.3610	1	17	0
	646.3710	1	30	0
	646.3711	1	17	0
	646.3712	1	20	0
	646.3713	1	24	0
	646.3714	1	23	0
	646.3715	2	17	0
	646.3716	1	16	0
	646.3717	1	22	0
	646.3718	2	24	0
	646.3719	2	16	0
	646.3810	2	19	0
	646.3811	1	6	0
	646.3812	2	18	0
	646.3813	1	13	0
	646.3910	4	53	0
	646.3911	1	21	0
	646.3912	4	25	0
	646.3913	1	16	0
	646.9410	1	78	0
	647.0112	2	38	0
	647.7703	2	10	0
	650.9201	2	41	0
	AN3-11A	10	351	0
	AN3-12A	2	98	0
	AN3-13A	1	50	0
	AN3-3A	4	315	0
	AN3-4A	10	328	0
	AN3-5A	2	367	0
	AN3-6A	2	475	0
	AN316C4R	2	50	0
	AN44-5A	2	45	0
	AN4C7A	2	121	0
	AN665-34R	2	46	0
	CCR264SS3-02	36	1,063	0
	CR3213-5-3	14	259	0
	MS20426AD5-7	2	907	0
	MS20470AD5-5.5	8	985	0
	MS20470AD5-6	8	862	0
	MS20470AD5-7	3	85	0
	MS21042L08	2	1,898	0
	MS21042L3	63	4,022	0

MS21042L4	2	3,987	0
MS21047-3	18	363	0
MS24693-C278	5	141	0
MS24694-S51	5	227	0
MS24694-S54	2	169	0
MS24694-S55	3	188	0
MS27039-08-13	2	477	0
MS27039-1-10	2	531	0
MS27039-1-12	6	185	0
MS27039-1-16	24	1,280	0
MS27039-1-19	22	867	0
MS27039-1-20	2	78	0
MS27039-1-21	4	30	0
NAS1149F0332P	144	5,184	0
NAS1149F0363P	2	463	0
NAS1149F0432P	4	2,099	0
NAS1149FN832P	4	2,286	0

Part Specifications

Specifications could not be found.

Plex 3/5/19 12:51 PM Dart.Quirion.Sonia

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NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24916.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	MS24694554				
1	1	1	77	646.9410	SHIM	AN3-11A				
	4	4	76	601.2764	WASHER	MS21042-08				
	2	2	75	601.2973	LOCKNUT	MS27039-0813				
	2	2	74	601.2988	SCREW	MS21042-03				
	2	2	73	601.2943	LOCKNUT	AN3-12A				
	2	2	72	601.3128	NUT	AN3-16CAR				
	2	2	71	601.3209	LOCKNUT	MS21042-08				
	4	4	70	601.2638	WASHER	MS21042-03				
	2	2	69	601.2669	BOLT	AN4C7A				
	2	2	68	601.3119	CLEVIS	AN665-34R				
	2	2	67	601.3121	EYE BOLT	AN44-5A				
	2	2	66	650.9201	EYE BRACKET ASSY					
	REF	REF	65	647.5701	GPS MOUNT KIT					
		2	64	601.3151	WASHER	MS21042-03				
		2	63	601.2911	SCREW	MS24694553				
	24	24	62	601.2637	SCREW	MS27039-1-16				
2	2	2	61	601.2763	BOLT	AN3-12A				
	1	1	60	646.3913	SHIM					
	4	4	59	646.3912	SHIM					
	1	1	58	646.3911	SHIM					
	4	4	57	646.3910	SHIM					
	5	5	56	600.1013	PRIMER					
	8 FT	8 FT	55	600.0129	VHB TAPE					
	1	1	54	600.1012	SEALANT	PR-1425 CLASS B				
	1	1	53	600.0991	MAGNOBOND 6396 PART B					
	1	1	52	600.0990	MAGNOBOND 6396 PART A					
6	10	10	51	601.2826	BOLT	AN3-11A				
		2	50	646.3814	WIPER BRACKET					
		2	49	601.2910	SCREW	MS27039-1-18				
	2	2	48	601.1365	SCREW	MS27039-1-10				
	2	2	47	646.3719	DOUBLER					
	2	2	46	646.3718	CUSTOM WASHER					
1		1	45	646.3717	DOUBLER					
	22	22	44	601.1948	SCREW	MS27039-1-19				
	2	2	43	601.1952	SCREW	MS27039-1-20				
	4	4	42	601.1956	SCREW	MS27039-1-21				
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 0219, 0220, 0221 & 0225	03/26/2015	P. BRAVO
B	INCORPORATED ECN 0304, 0309 & 0431	11/04/2014	P. BRAVO
C	INCORPORATED ECN 0098	06/09/2014	P. BRAVO

		2		2	41	601.2829	SCREW	MS24694554		
		2		2	40	601.2831	RIVET	MS20470ADS-7		
		1		1	39	646.3716	GAUGE BRACKET			
		6		6	38	601.1953	SCREW	MS27039-1-12		
	2	2		2	37	646.3715	STRUT DOUBLER			
		2		2	36	601.2824	BOLT	AN3-5A		
12	36			36	35	601.2277	RIVET	CCR06453-02		
6	18			18	34	600.0795	NUTPLATE	MS21047-3		
3	3			3	33	601.2565	RIVET	MS20470ADS-7		
1	1			1	32	646.3813	STRUT BRACKET			
4	4			4	31	601.2822	BOLT	AN3-3A		
2	2			2	30	646.3812	GUSSET BRACKET			
8	8			8	29	601.2564	RIVET	MS20470ADS-6		
1	1			1	28	646.3714	GUSSET			
	1			1	27	646.3610	FILLER			
	3			3	26	601.2830	SCREW	MS24694555		
	2			2	25	601.2825	BOLT	AN2-6A		
	1			1	24	646.3811	RADIUS BLOCK			
	1			1	23	646.3712	CLIP			
	1			1	22	646.3711	CLIP			
6	8			8	21	601.2832	RIVET	MS20470ADS-8.8		
14	14			14	20	601.2020	RIVET	CR3213-5-3		
4	6	4	6	10	19	601.2823	BOLT	AN3-4A		
	1		1	1	18	601.2827	BOLT	AN3-13A		
	5		5	5	17	601.2912	SCREW	MS24694551		
1	1			1	16	646.3713	GUSSET			
1	1			1	15	646.3210	SUPPORT			
		1		1	14	646.3710	DOUBLER			
		1		1	13	646.3110	CHANNEL			
14	10	8	53	6	61	12	601.1624	LOCKNUT	MS21042L3	
16	32	18	120	16	144	11	601.1607	WASHER	NAS114P032P	
					10		646.3710	WIPER DEFLECTOR		
				1	9		646.3711	WIPER DEFLECTOR		
		2		2	8		647.7203	STRUT ASSY		
		2		2	7		647.0112	STRUT BRACKET		
	1	1		1	6		646.3511	STRUT		
	1	1		1	5		646.3510	STRUT		
2	2			2	4		646.3810	BRACKET		
		1		1	3		646.2910	DEFLECTOR		
	1	1		1	2		646.3001	LOWER CUTTER ASSY		
		1		1	1		646.3301	UPPER CUTTER ASSY		
X							646.4006	LOWER CUTTER FIXED PROVISIONS		
	X						646.4005	LOWER CUTTER REMOVABLE PROVISIONS		
		X					646.4004	FIXED PROVISIONS KIT		
			X				646.4003	CABLE CUTTERS KIT WITHOUT FIXED PROVISIONS		
				X			646.4002	ASS350 WIPER DEFLECTOR KIT		
					X		646.4001	ASS350 CABLE CUTTERS KIT		
4006	4005	4004	4003	4002	4001	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE: 08-27-06 DRAWN BY: [] CHECKED BY: P. BRAVO DRAWING APPROVAL: [] CONTRACTING: []	
DIMENSIONS ARE IN INCHES TOLERANCES ARE: FINISH: [] ANGLE: 45°		3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5300 AS350 CABLE CUTTERS KIT DOW: NO 646.4000 SCALE: NONE SHEET 1 OF 5	